

**Work Order ID 70980**

Monday, June 20, 2011 2:47:48 PM



Page 1

Item ID: D3405-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 6/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11-06-20 Tooling:

Date: \_\_\_\_\_

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N):

Date: \_\_\_\_\_

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
**Set Up/  
Run Hours**

## Tool ID

## Tool #

**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**

Draw Nbr	Revision Nbr								
D3405	Rev B								

100



FLOW WATER JET

Waterjet

Memo

0.00

B11-6-21

FLOW CNC Waterjet

304 - 178

1-Cut as per Dwg D3405  
Dwg Rev: B  
Prog Rev: B  
2-Deburr if necessary

(12)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B11-6-21

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

0.00

S u/o 6/21

Quality Control

(X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

NC BRAKE

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Brake NC

Memo

0.00

(12)

Brake NC

1-Deburr  
2-Form using DT8204 as per Dwg D3405  
3- use DT9681 to check if correct forming

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/20/14

(12)

Memo

0.00

150



Large Fab

Large Fab

0.00

EL 11-8-25 (17)

Large Fab

Memo

0.00

Weld as per Dwg D3405 use DT8484  
Identify as D3405-041

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 3

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Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 6/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Page 4

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Item Name: Lug Assembly

Stop



Start Date: 6/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

200



Packaging

Packaging

Identify as per dwg & Stock Location: ST 478 0.00

Memo

0.00

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Page 1

Monday, June 20, 2011 2:47:56 PM

Work Order ID: 70980



Parent Item: D3405-041



Parent Item Name: Lug Assembly

Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 10.00

Required Qty: 10.00

**Comments:** IPP A□05.09.01□New issue□KJ/JLM□  
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1 		Manufactured	No			100	Each	35.0000	1	10		EZ 11-8-24	

GHW Lug

72326 x 12

Location

WA	Loc Qty	Loc Code
69883	32	
WA030	32	
67127	3	
	3	

M304S11GA



304/316 0.125 Sheet

Purchased

Location

MAT020	Loc Qty	Loc Code
117494	.113	

(12)

117494

D3405-1 X 5 EZ 11-8-24  
B72072

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70980
Description: GHW Lug	Part Number:	D3405-1
Inspection Dwg: D3405      Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 11-6-21	Date: 11/6/21	Date: N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	08.11.28	New Issue P/O D3405-041	KJ/EC	
B	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

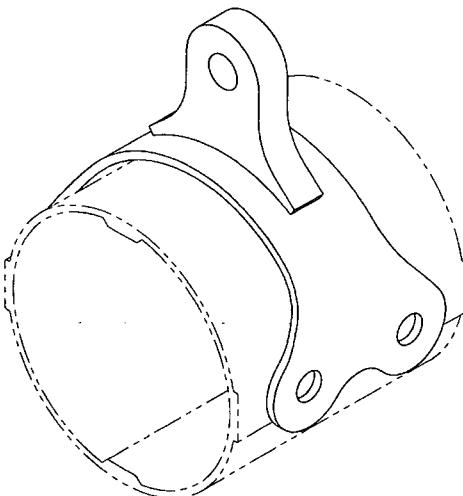
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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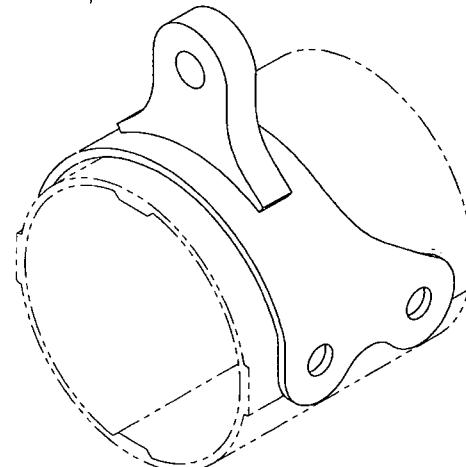
NOTE: Date & initial all entries

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70980  
PH-De-20



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)



**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

RELEASED  
*07/18/11*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.			AJS	08.09.19
A	NEW ISSUE			PH	05.03.08
REV.	DESCRIPTION			BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED		DRAWING NO.	D3405	REV. B	
MFG. APPR.				SHEET 1 OF 4	
APPROVED		TITLE	GHW LUG ASSEMBLY	SCALE	NTS
DE APPR.		DATE	08.09.19		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

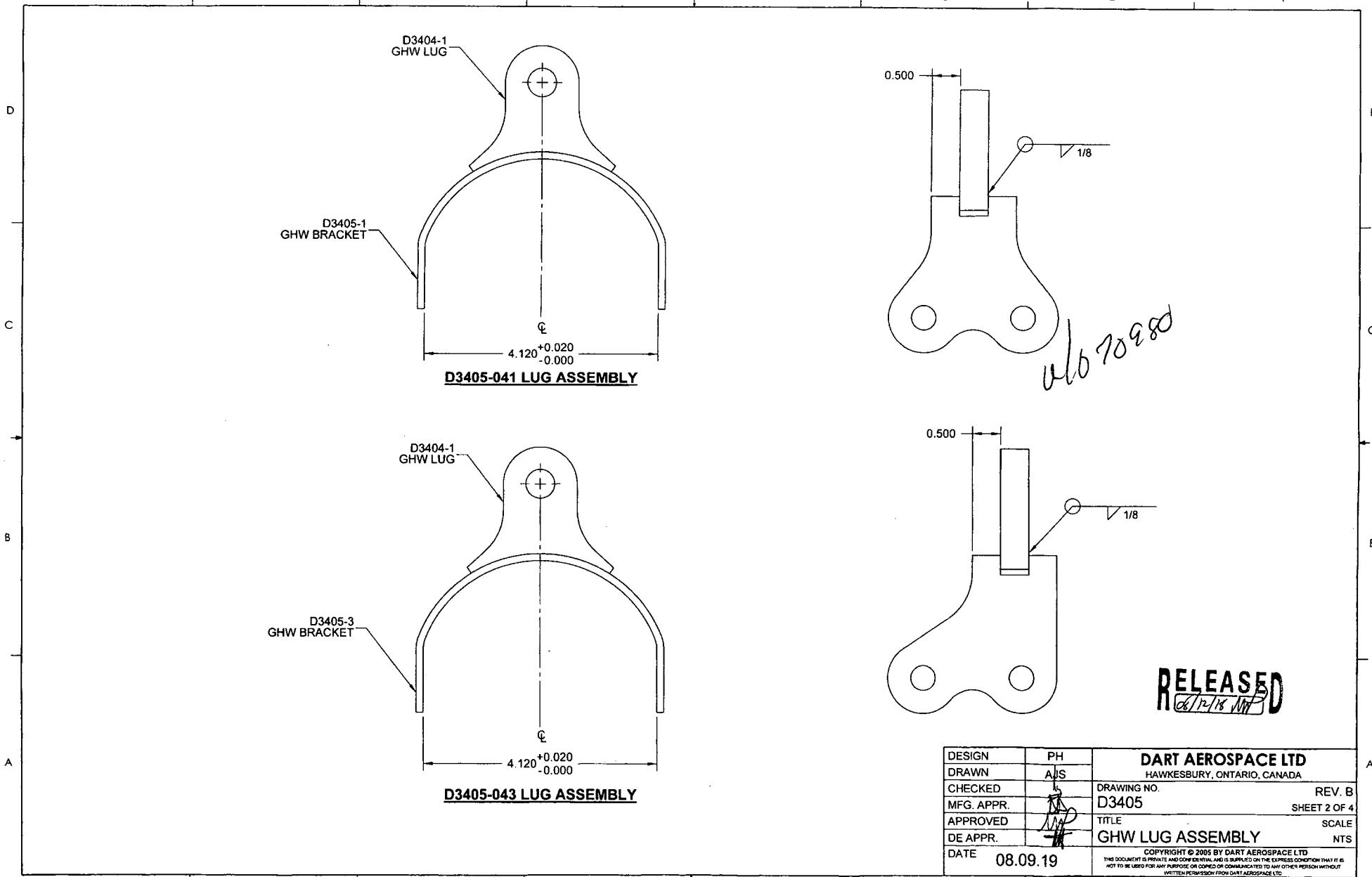
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3405	REV. B
APPROVED		SHEET 2 OF 4	
DE APPR.		TITLE	SCALE
DATE	08.09.19	GHW LUG ASSEMBLY	NTS

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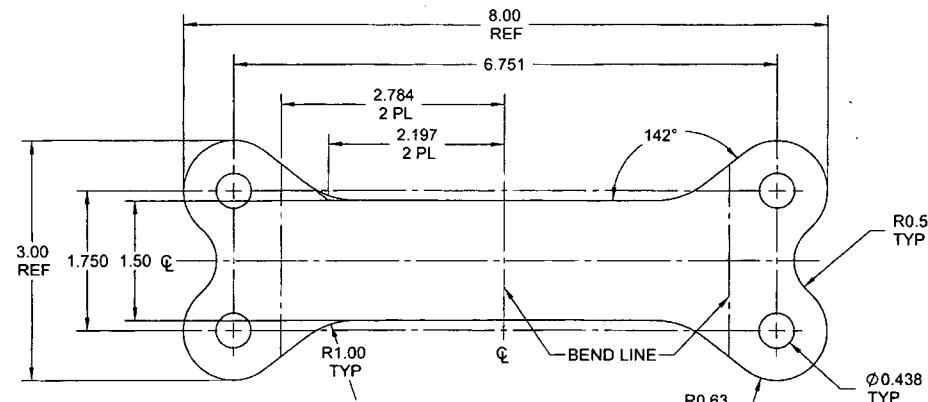
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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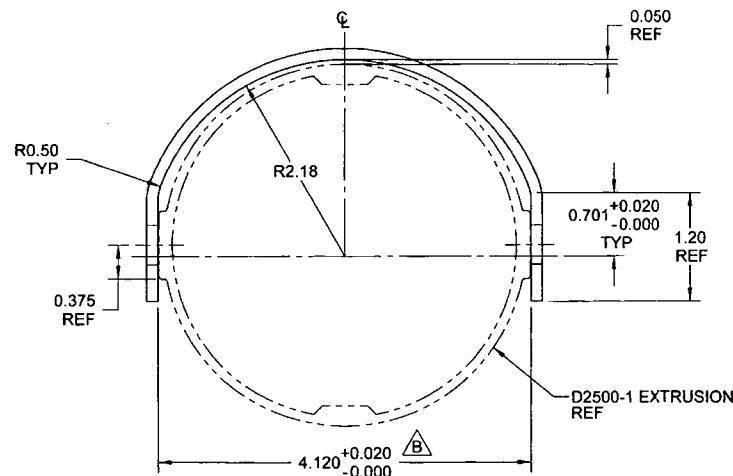
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NOTE: Date & initial all entries



10980

**D3405-1F GHW BRACKET FLAT PATTERN**



**D3405-1 GHW BRACKET**  
(MAKE FROM D3405-1F)

SIDE VIEW FOR REF ONLY

RELEASER  
MP 08/12/16

**NOTES:**

- NOTES:  
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.	<i>[Signature]</i>	D3405	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	GHW LUG ASSEMBLY	NTS	
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

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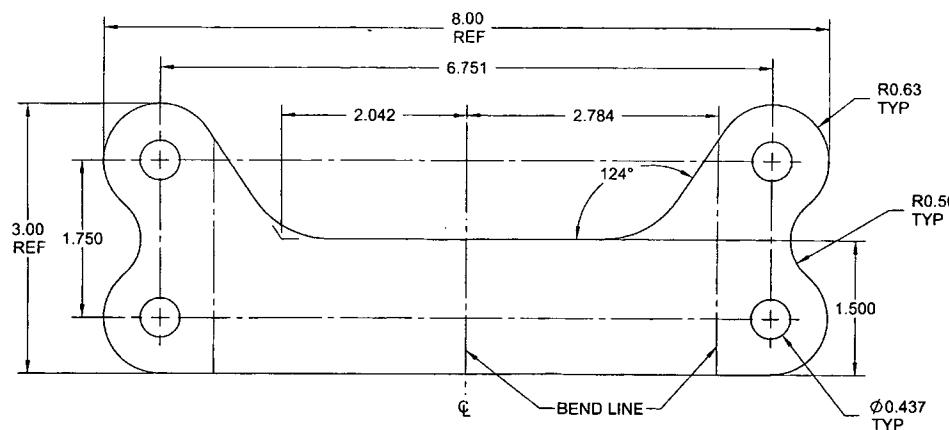
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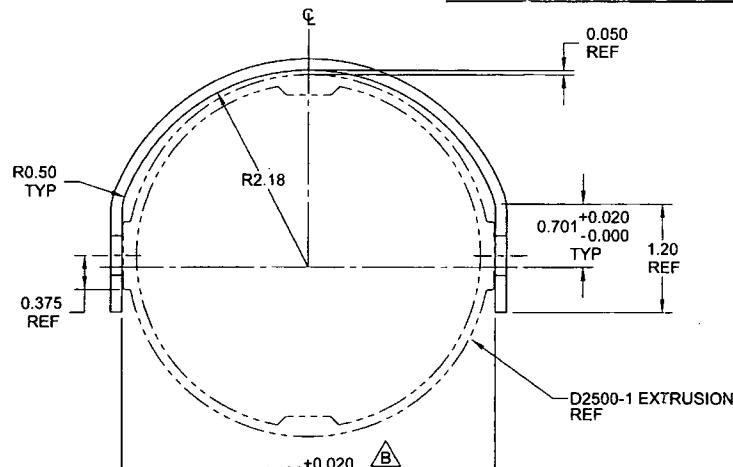
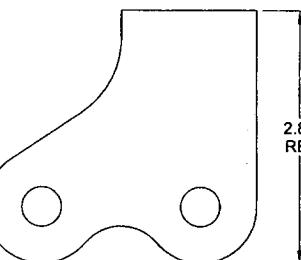
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8 7 6 5 4 3 2 1



WU 10980

D3405-3F GHW BRACKET FLAT PATTERND3405-3 GHW BRACKET  
(MAKE FROM D3405-3F)

SIDE VIEW FOR REF ONLY

RELEASED  
08/12/14 M

A

## NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S1GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

8 7 6 5 4 3 2 1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. B	
APPROVED		D3405	
DE APPR.		SHEET 4 OF 4	
DATE	08.09.19	TITLE	GHW LUG ASSEMBLY
		SCALE	NTS

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1

W/O:		WORK ORDER CHANGES					
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